

Date: Thursday, 4/5/2007 11:58:53 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEB	
Job Number	31689		Part Number	D21741	
Estimate Number	10195		Drawing Number	D2174-1 REV E	
P.O. Number	N/A		Project Number	N/A	
This Issue	4/5/2007	S.O. No.	N/A	Drawing Revision	E
Prsht Rev.	NC		Material	N/A	
First Issue	N/A		Due Date	4/30/2007	
Previous Run	30870		Qty:	36	
Written By			Um:	Each	
Checked & Approved By	D.07.04.05				
Comment	Est C 04/06/09 Reformat KJ/RF Est Rev:D As per Rev E 06-11-22 JLM				

## Additional Product

Job Number:  
SIC



Seq. #:	Machine Or Operation:	Description:
1.0	M2024T3S063	2024-T3 .063 sheet
	Comment: Qty.: 0.4958 sf(s)/Unit Total : 14.8743 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)	Batch: M103321 SAD 07/05/17 36
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2174 Dwg Rev: E Prog Rev: E	SAD 07/05/17 36
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/05/17 36
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	7/05/17 36 counted
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack	MF 07-05-23 36

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/24  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:58:53 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 31689

Part Number: D21741

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 07/05/23 (36)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SD/BL

07/05/24 (36)

8.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SD 7/05/24 (36)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

SD 7/05/24 (36)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 07/05/24 (36)

Job Completion



SD 07/05/24 (36)

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31689
Description: Web	Part Number:	D2174-1
Inspection Dwg: D2174 Rev: E		Page 1 of 1

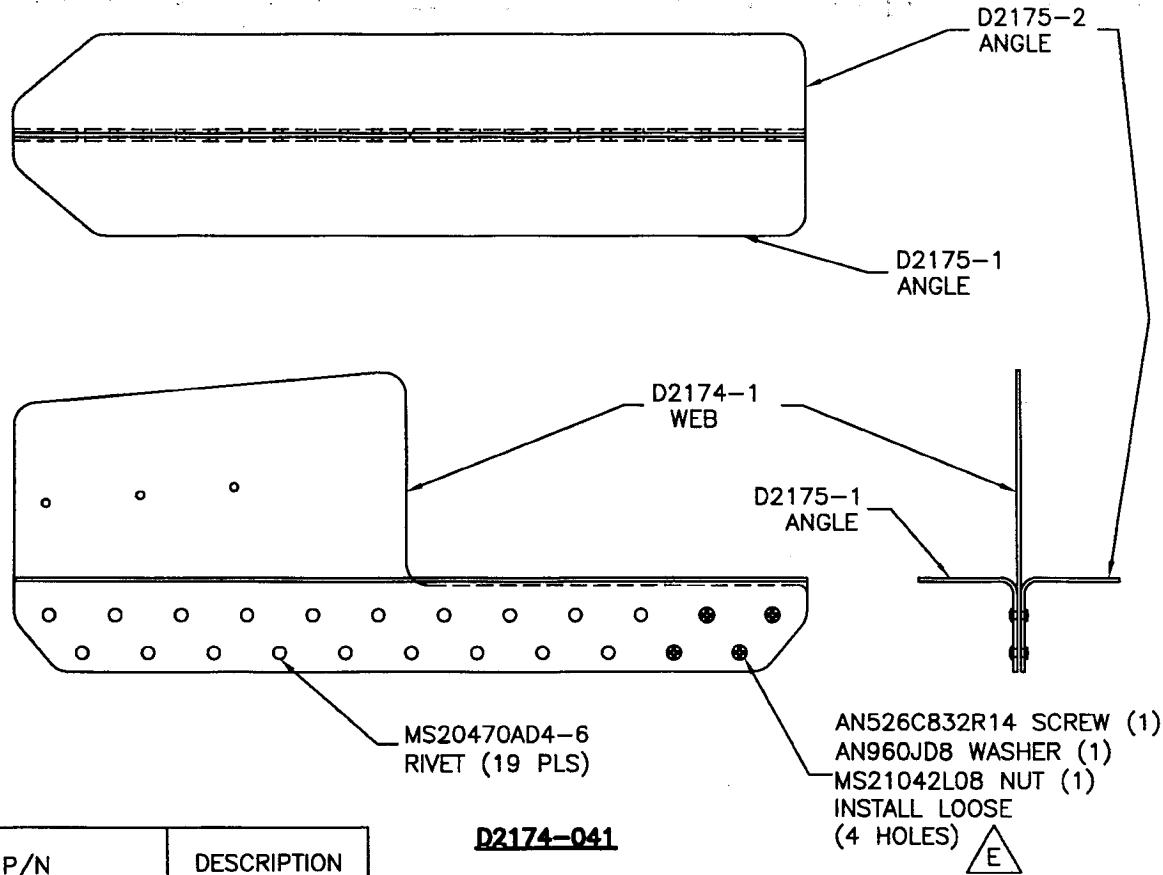
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>S40</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	<u>07/05/17</u>	Date:	<u>07/05/22</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	<i>[Signature]</i>



**DART**

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

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WITHOUT NOTICE  
NO. 31689

**RELEASED**

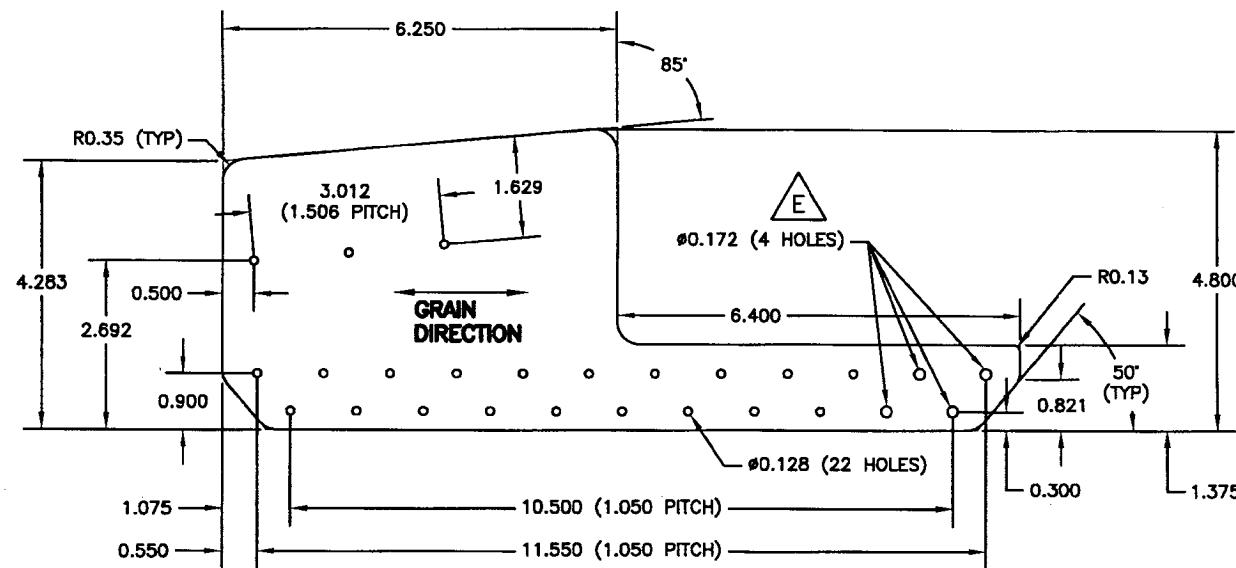
06-10-13

DESIGN RF	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED CH	DRAWING NO. D2174	REV. E SHEET 1 OF 2 SCALE 1:3
DATE 06.09.25		TITLE WEB ASSEMBLY	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO #0.172; CHG HARDWARE	

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

**DART**



D2174-1

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

ALL DIMENSION ARE IN INCHES

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WORK ORDER  
NO. 31689

**RELEASED**  
06-16-03

DESIGN <b>RF</b>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <b>PH</b>	APPROVED <i>MM</i>	DRAWING NO. <b>D2174</b>
DATE <b>06.09.25</b>		SCALE 1:3